

Work Order ID 153155***153155***

Page 1

Tuesday, November 08, 2016 11:19:18 AM

Item ID: D4435-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mount Bracket
Start Date: 11/18/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/23/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS Date: NOV 10 2016 Tooling: _____ Date: _____
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____
9-89

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4435	B						DAS 46 9-89	16/11/17	
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
38
9-89
NOV 18 2016

Work Order ID 153155

Tuesday, November 08, 2016 11:19:18 AM

153155

Page 2

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.02			DAS 30 9-89	2			NOV 21 2016
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2			DAS 38 9-89 NOV 27 2016
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.02				(x2)			206 M/12 BEB

Work Order ID 153155

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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				2			DAS 38 9-89 NOV 22 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : GA	0.00 0.00				2			DAS 6 9-89 NOV 13 2016
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03							16/11/24 JF DAS 21 9-89 NOV 23 2016

Picklist Print

Tuesday, November 08, 2016 11:19:18 AM

Page 1

Work Order ID: 153155

153155

Parent Item: D4435-5

D4435-5

Parent Item Name: Mount Bracket

Start Date: 11/18/2016

Required Date: 11/23/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased			No	100	sf	317.1300	0.1732	0.364632			
M6061T6S 040									**				
6061-T6 .040 Sheet													

DAS
46
9-89

16/11/18

Location

Loc Qty

Loc Code

MAT021

317.13

m135147

1

m135612

39.61

m135632

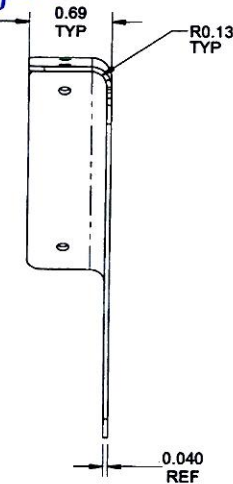
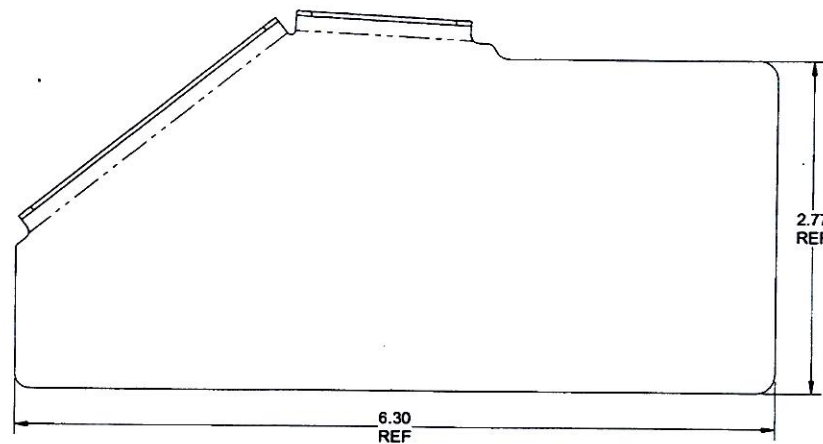
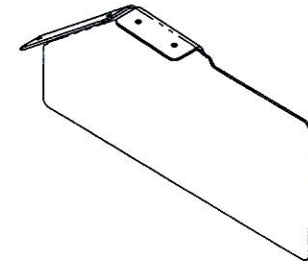
103.7

m135724

172.82

0.38

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153155 MLS
1671-10



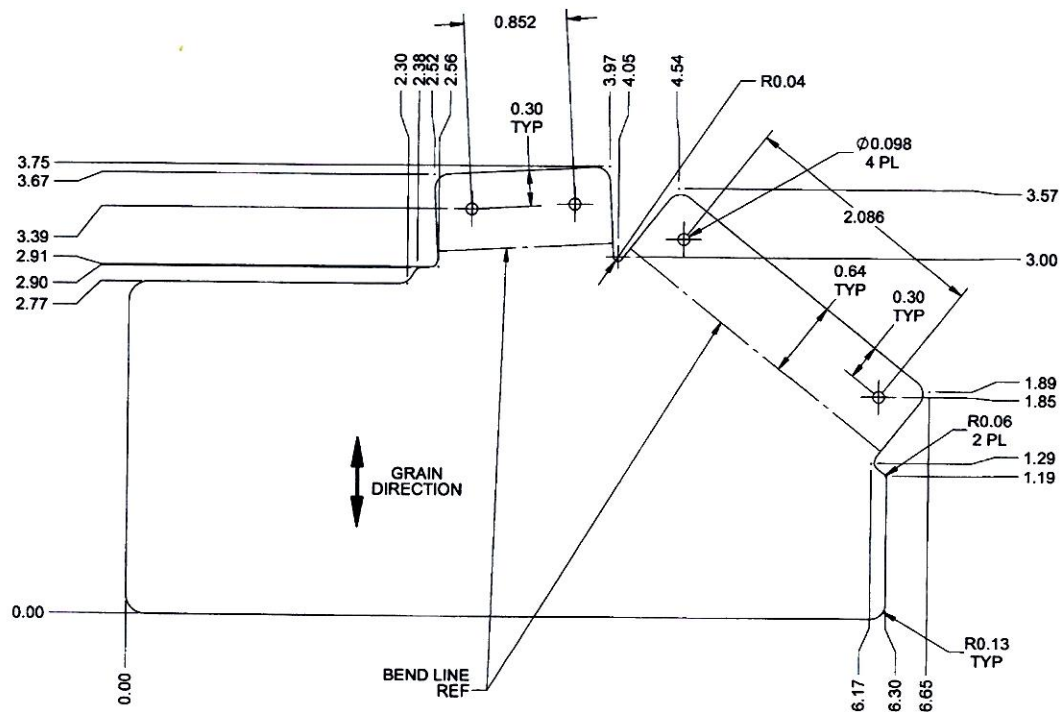
D4435-5 MOUNT BRACKET

RELEASED
2012-03-02
JNN

NOTES:

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	D4435	SHEET 6 OF 11
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	BRACKET	NTS
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D4435-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
2012-03-02
JMD

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